

Date: Wednesday, 30/04/2008 10:22:50 AM
 User: Julie Lecocq

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : LONG STEP ASSEMBLY HIGH SKID RH |
| Job Number : 38903 | |
| Estimate Number : 10274 | |
| P.O. Number : | Part Number : D350591312 |
| This Issue : 30/04/2008 S.O. No. : | Drawing Number : D3272 REVB |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : B |
| Previous Run : 38510 | Material : |
| Written By : | Due Date : 30/05/2008 Qty: 5 Um: Each |
| Checked & Approved By : <u>JLD 08.4.30</u> | |
| Comment : Est Rev:A 04.03.22 New issue KJ/RF | |
| Est Rev:B 07-06-09 Added D3572-1 JLM | |
| Est Rev:C 08-04-02 ECN1163 DD verified by:EC | |
| Est Rev:D 08-04-08 ECN1164 DD verified by: | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL
 Photocopy bluefile and type labels as per PPP D350-591-312 CHG002

JLD
08.5.02

| | | |
|-----|--------|------|
| 2.0 | D32721 | Step |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 STEP
 BATCH: 338928

08.05.15 5

| | | |
|-----|--------|-----------|
| 3.0 | D30671 | End Plate |
|-----|--------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 1 D3067-1 End Plate 337571

08.05.15 5

| | | |
|-----|--------|-------|
| 4.0 | D32191 | Plate |
|-----|--------|-------|



Comment: Qty.: -2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D3219-1 Support 337886

08.05.15 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY.HIGH SKID RH

Job Number: 38903

Part Number: D350591312

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------------|------------------------------|
| 5.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

✓ 1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M106834
M107678

3-Grind End Plate flush

PH 08.05.15 5

PH 08.05.15 5

PH 08.05.15 5

| | | |
|-----|-----|---------------------------|
| 6.0 | QC9 | VISUAL WELDING INSPECTION |
|-----|-----|---------------------------|



Comment: VISUAL WELDING INSPECTION

PD 08.05.20 (5)

| | | |
|-----|-----|------------------------------|
| 7.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

2 08/05/20 (5 PH)

| | | |
|-----|-----------------|----------------------------|
| 8.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PH / BR 08-05-20

(5 PH)

| | | |
|-----|-----|---|
| 9.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PH 08.05.20 5

| | | |
|------|----------|----------------------|
| 10.0 | D3065041 | Step Leg Assembly Hi |
|------|----------|----------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

✓ Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|---------------|--------|
| 1 | D3065-041 | Step Leg Assy | 835625 |

PH 08.05.20 5

| | | |
|------|--------|--------|
| 11.0 | D30661 | Spacer |
|------|--------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

✓ Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 2 | D3066-1 | Spacer | 338925 |

PH 08.05.20 5

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 30/04/2008 10:22:51 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 38903

Part Number: D350591312

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|--------------|--------|
| 12.0 | MS20600AD4W4 | Rivets |
|------|--------------|--------|



Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet *mic7956*

PL 08.05.20

5

| | | |
|------|-------------|------------------------------|
| 13.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|------|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

SP/PL 08.05.20

5

| | | |
|------|-----|------------------------------|
| 14.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

6 2 08.05.21 (15 LH)

| | | |
|------|--------|-----------|
| 15.0 | D30671 | End Plate |
|------|--------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate *331571*

PL 08.05.21

5

| | | |
|------|-------------|------------------------------|
| 16.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|------|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *m106834*

4-Grind End Plate flush

5-Install last rivet.

PL 08.05.21

PL 08.05.21

PL 08.05.21

PL 08.05.21

PL 08.05.21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 38903

Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-05-21 (5)

18.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/21 (15 RH)

19.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

M-L

08/05/21

SX RH

20.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

3:50 PM

OVEN TEMPERATURE:

320 °F

FINISH TIME:

4:20 PM

M-L

08/05/21

SX RH

21.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

M107842

RL/M-L

08/05/22

SX RH

22.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

RL/M-L

08/05/22

SX RH

23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0 D22303 Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

37918-16 B 38532 x4

AS 08/05/23 (15)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 38903

Part Number: D350591312

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|-------|---------|
| 25.0 | D2618 | Bushing |
|------|-------|---------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618 Bushing 35628

JS 08/05/23 (X5)

| | | |
|------|----------|----------------|
| 26.0 | D2732030 | Rubber Cushion |
|------|----------|----------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Rubber Cushion

batch: B 37622

IN comp. said 50ty.
But this one
is correct.

JS 08/05/23 (X5)

| | | |
|------|--------|--------------|
| 27.0 | D32351 | Mounting Lug |
|------|--------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1 Mounting Lug 37933

JS 08/05/23 (X5)

| | | |
|------|----------|------------------|
| 28.0 | D3278041 | Support Assembly |
|------|----------|------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 Support Assembly 38929

JS 08/05/23 (X5)

| | | |
|------|-------------|----------------|
| 29.0 | D3595200300 | RUBBER CUSHION |
|------|-------------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

RUBBER CUSHION

batch: 38498

JS 08/05/23 (X5)

| | | |
|------|--------|------|
| 30.0 | AN335A | Bolt |
|------|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M100993

JS 08/05/23 (X5)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 30/04/2008 10:22:51 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 38903

Part Number: D350591312

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|--------|------|
| 31.0 | AN415A | Bolt |
|------|--------|------|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

batch: M107321

AS 08/05/23 (X5)

| | | |
|------|--------|------|
| 32.0 | AN536A | Bolt |
|------|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A Bolt M107715

AS 08/05/23 (X5)

| | | |
|------|-----------|--------|
| 33.0 | AN960JD10 | Washer |
|------|-----------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer M107799

AS 08/05/23 (X5)

| | | |
|------|------------|--------|
| 34.0 | AN960JD416 | Washer |
|------|------------|--------|



Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer M107321

AS 08/05/22 (X5)

| | | |
|------|------------|--------|
| 35.0 | AN960JD516 | Washer |
|------|------------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M107534

AS 08/05/22 (X5)

| | | |
|------|-----------|-----|
| 36.0 | MS21042L3 | Nut |
|------|-----------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M107644

AS 08/04/22 (X5)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 38903

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M166051

38.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

M167464

39.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-312

Location:

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|----------------------|--------------------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3272 | REV. B SHEET 1 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG SCALE NTS | |
| A | 04.03.01 | NEW ISSUE | |
| B | 07.05.18 | D3272-1 WAS D2622-120 | |

RELEASED

07.06.04

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|-------------------------------|
| X | | D3272-041 | STEP ASSEMBLY, HIGH LONG (LH) |
| | X | D3272-042 | STEP ASSEMBLY, HIGH LONG (RH) |
| | | | |
| 1 | 1 | D3065-041 | LEG ASSEMBLY |
| 2 | 2 | D3066-1 | SPACER |
| 2 | 2 | D3067-1 | END PLATE |
| 2 | 2 | D3219-1 | SUPPORT |
| 1 | 1 | D3272-1 | STEP |
| | | | |
| 16 | 16 | MS20600AD4W4 | RIVET . |
| | | | |

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

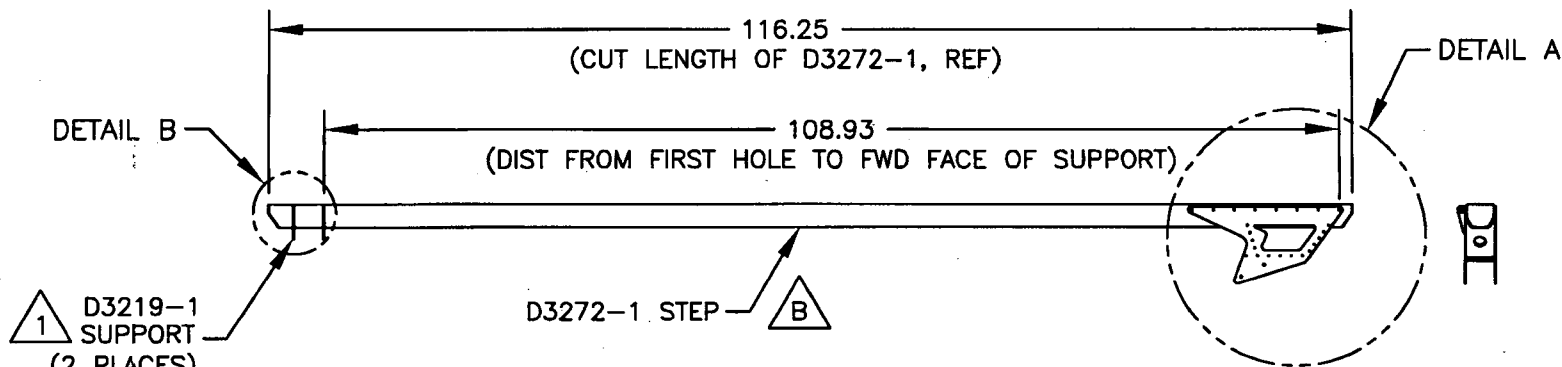
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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38903

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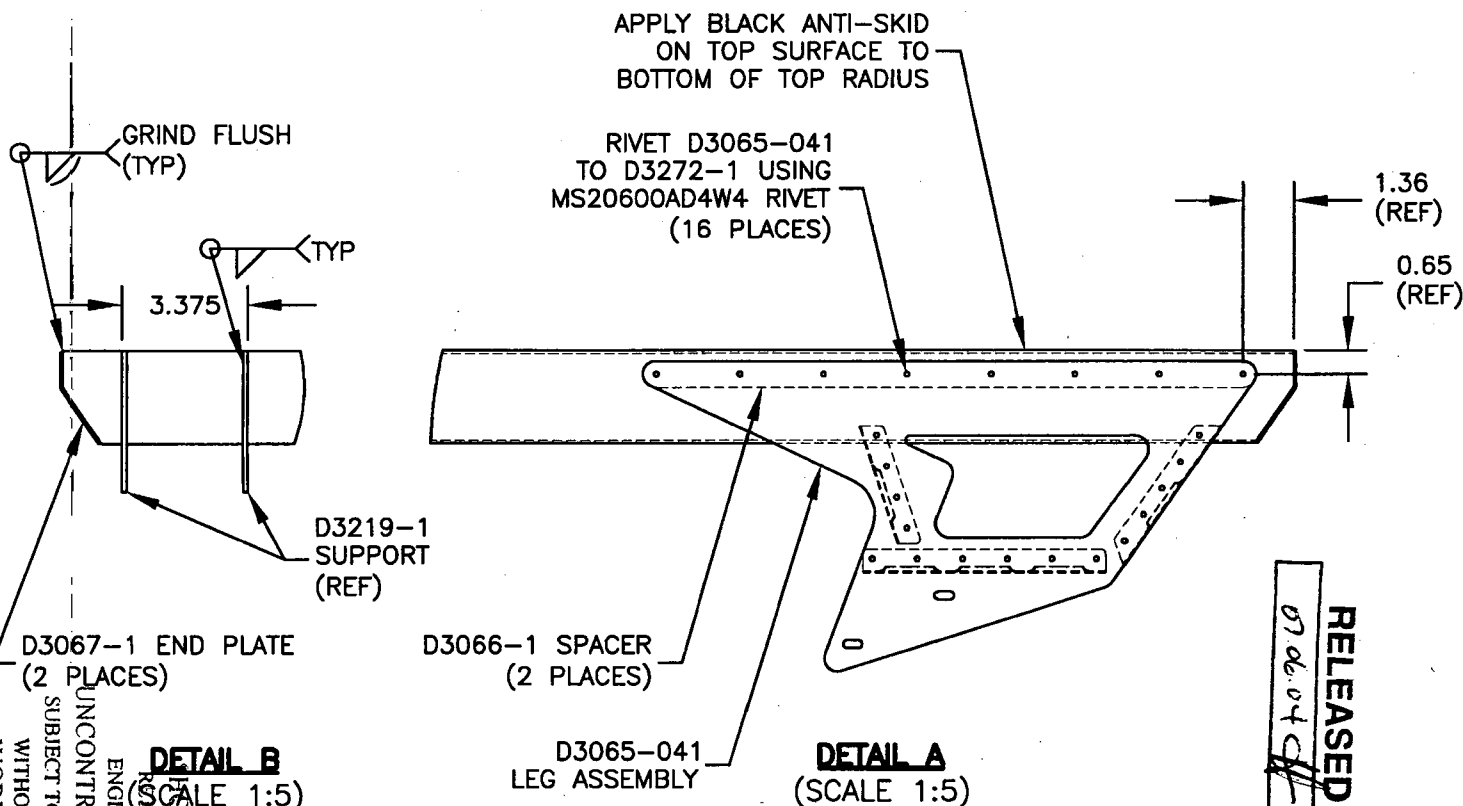
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DART

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|----------|----------|------------------------|-----------------------------|
| DESIGN | APPROVED | DRAWN BY | DART AEROSPACE LTD |
| CHECKED | APPROVED | DRAWING NO. | HAWKESBURY, ONTARIO, CANADA |
| DATE | | TITLE | REV. B |
| 07.05.18 | | STEP ASSEMBLY, HI LONG | SHEET 2 OF 3 |
| | | | SCALE |
| | | | 1:20 |



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



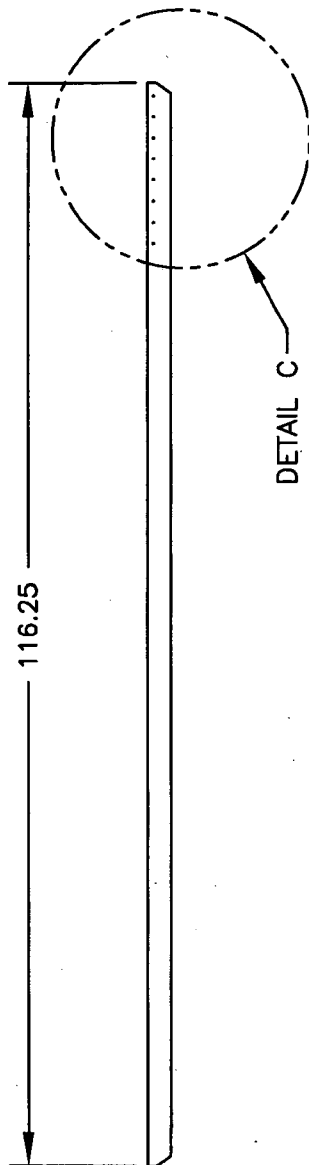
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 58903

DART

| | | | |
|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3272 | REV. B SHEET 3 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE 1:20 |

RELEASED

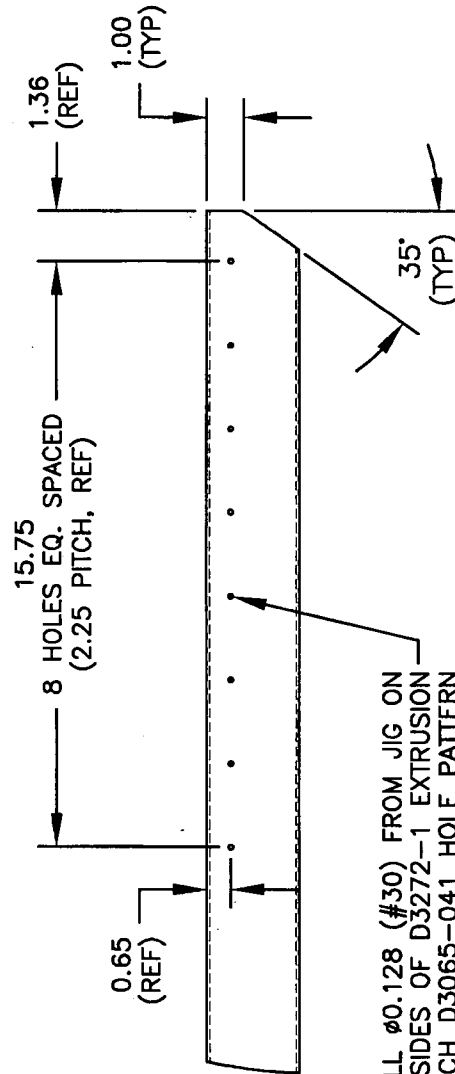
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

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